

Date: Monday, 2/19/2007 8:07:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 30750		Part Number	: D353515	
Estimate Number	: 12736		Drawing Number	: D3535 UNDER REVIEW Rev A. 07.02.19	
P.O. Number	: N/A		Project Number	: N/A.	
This Issue	: 2/19/2007	S.O. No. : N/A	Drawing Revision	: U/R	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/26/2007	
Previous Run	: N/A		Qty:	12	Um: Each
Written By					
Checked & Approved By					
Comment	: Est Rev:A New Issue 07-02-15 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
Comment: Qty.: 1.0715 sf(s)/Unit Total : 12.8583 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: M101873		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: A Prog Rev: A		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30750

Part Number: D353515

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/07 (12)

7.0 POWDER COATING

POWDER COATING



A101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MF | M-H 07-03-07 (12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AM - 07-03-07 (12)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

MF

07-03-08

(12)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

(12)

Job Completion



U 07/03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

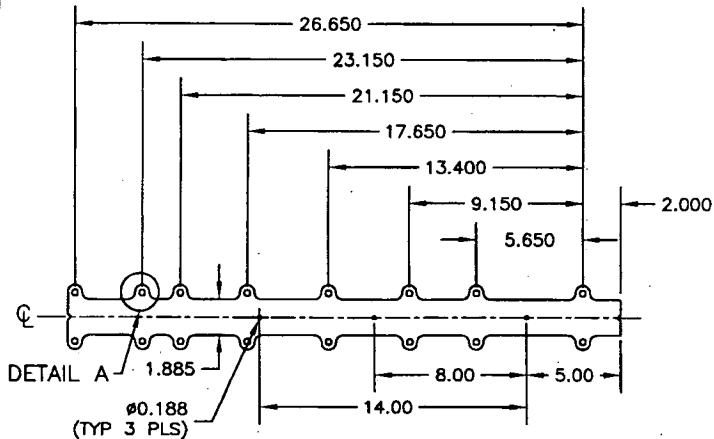
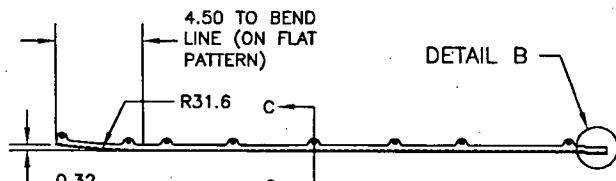
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

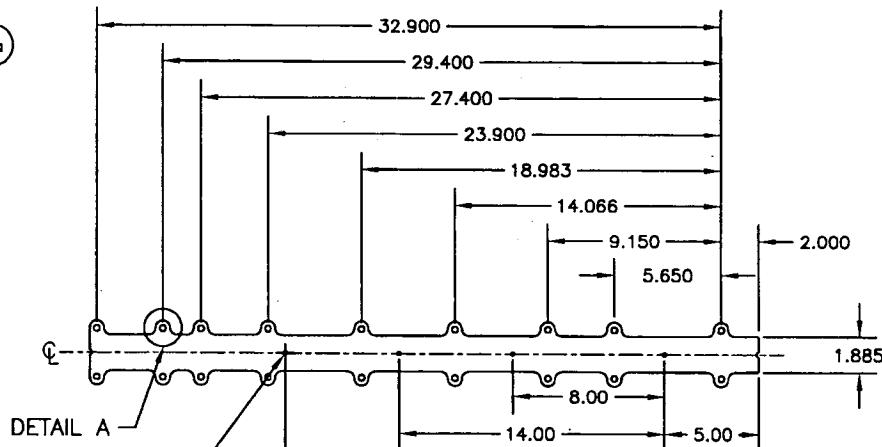
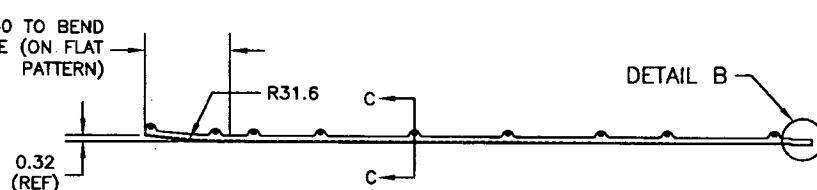
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3535
DATE 06.10.25	TITLE WEARSHOE	SCALE 1:10

07.02.12**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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WORK ORDER
NO. 30750

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

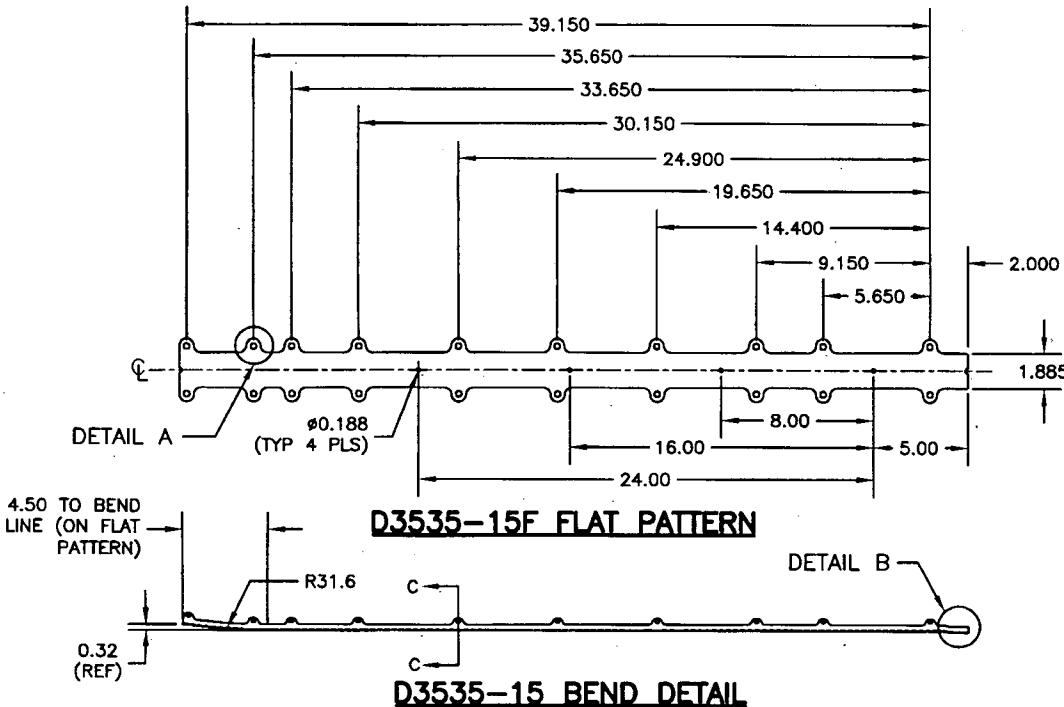
**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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REV. A
SHEET 2 OF 7
SCALE
1:10

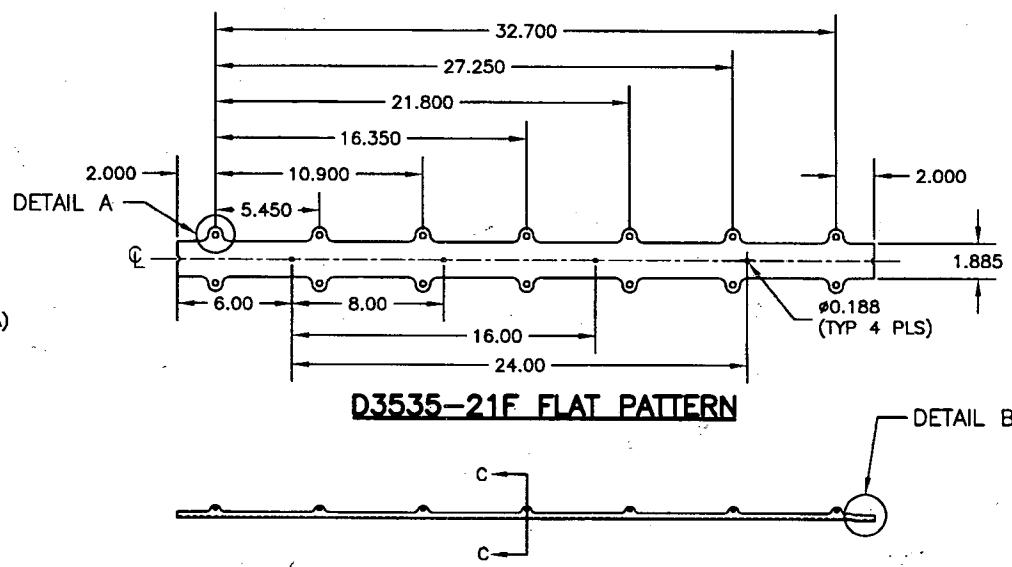
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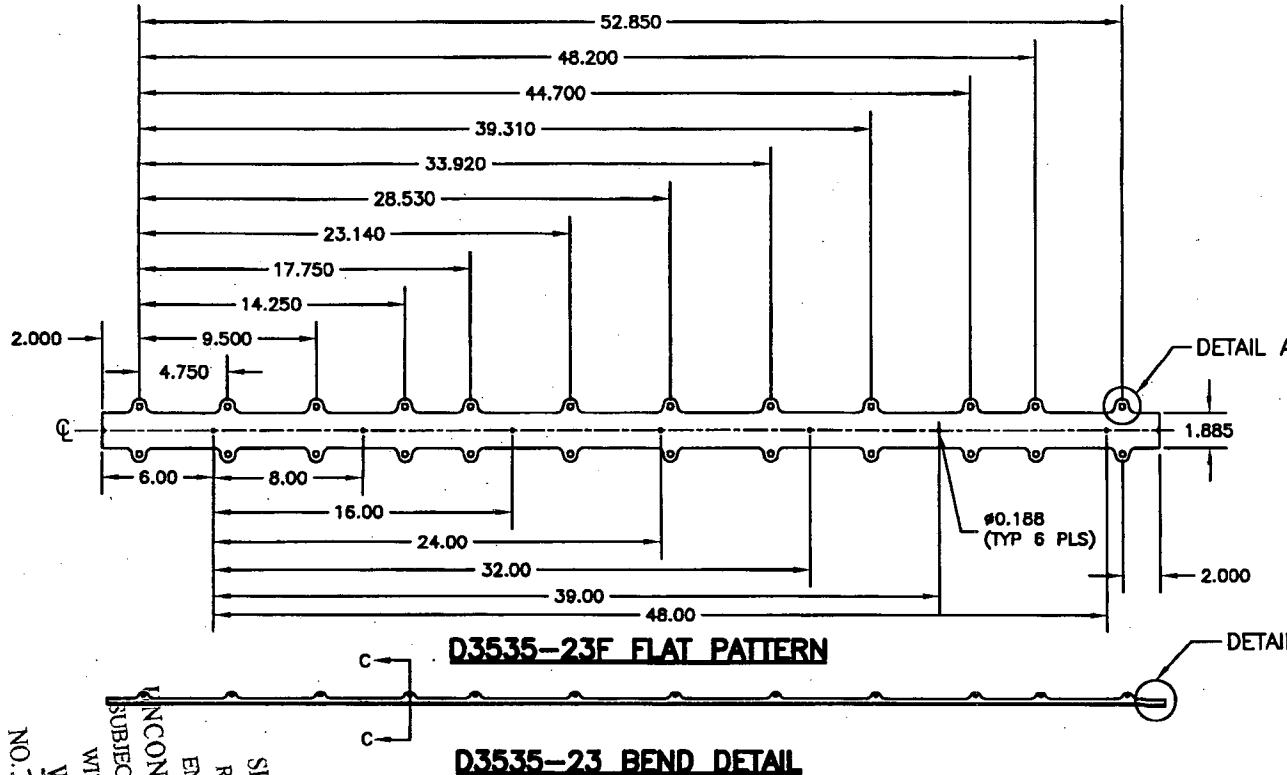
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		TITLE	WEARSHOE	SHEET 3 OF 7

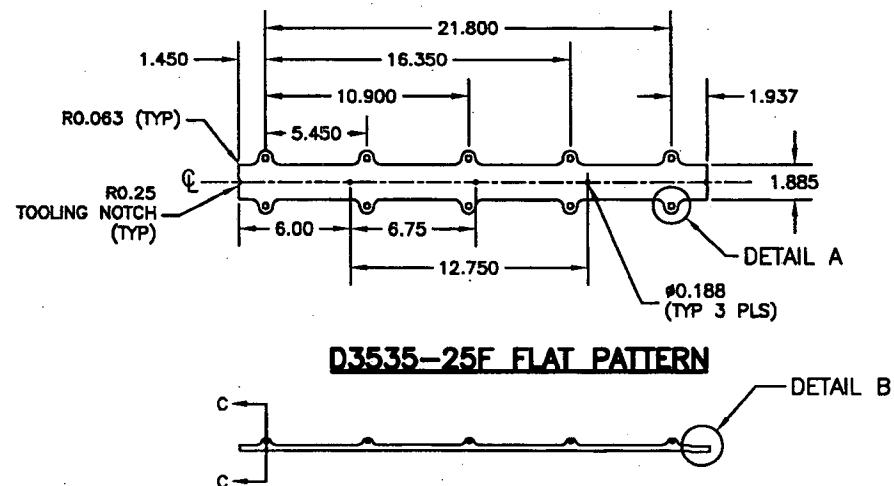
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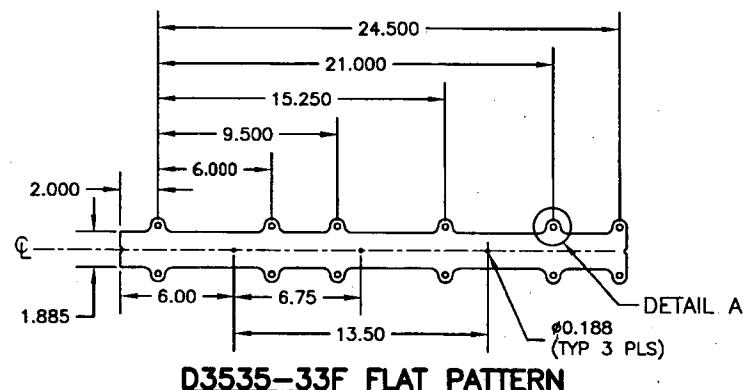
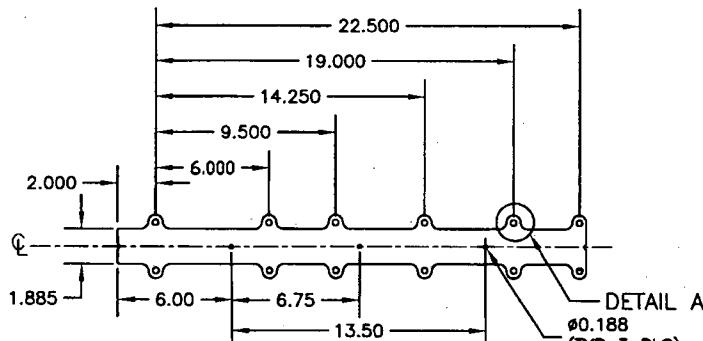
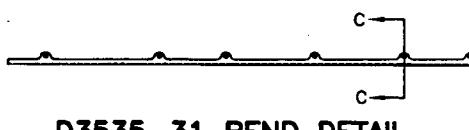
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07.02.12 *CH***D3535-33 F BEND DETAIL****D3535-31 F FLAT PATTERN****D3535-31 BEND DETAIL**

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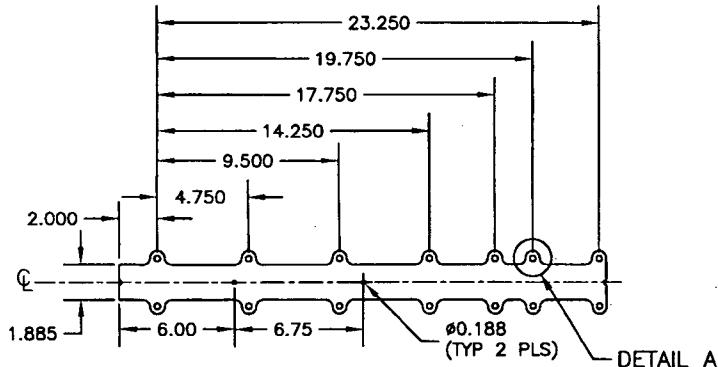
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Q



D3535-35F FLAT PATTERN



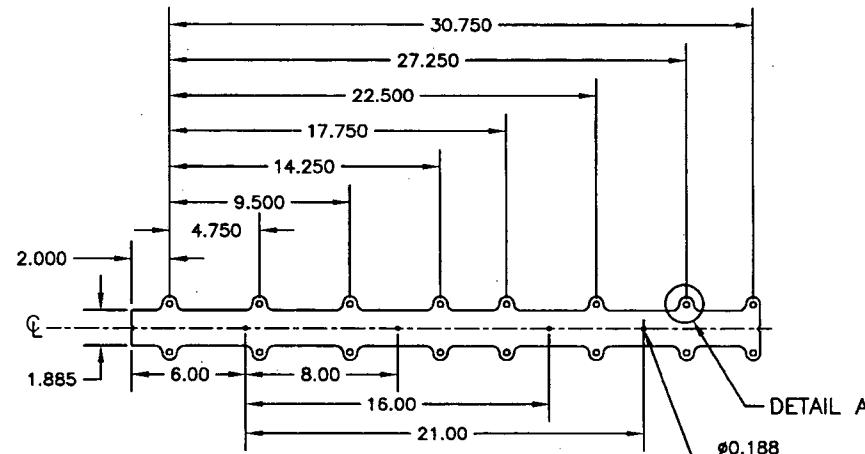
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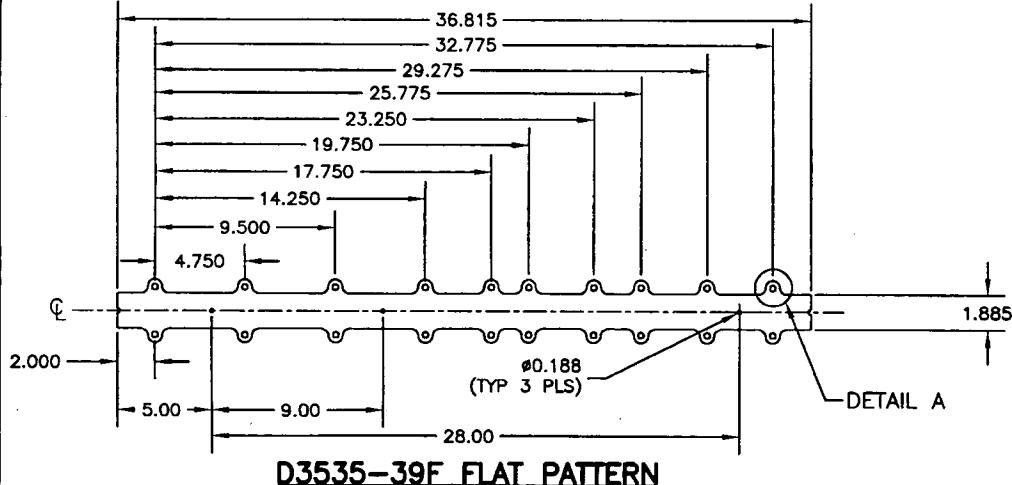
D3535-37F FLAT PATTERN



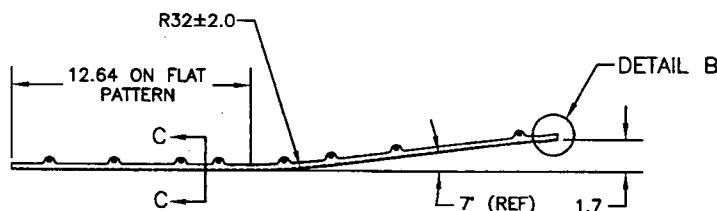
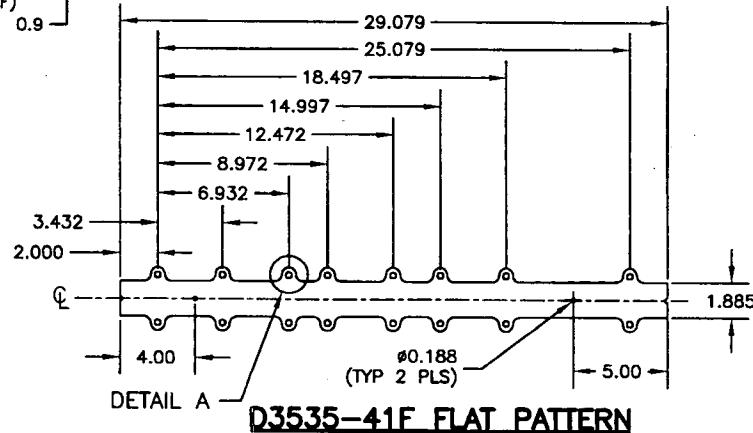
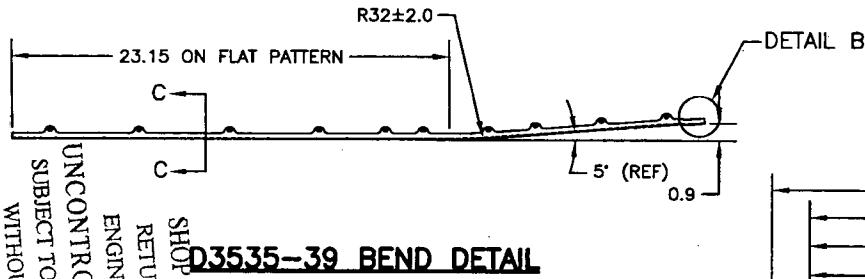
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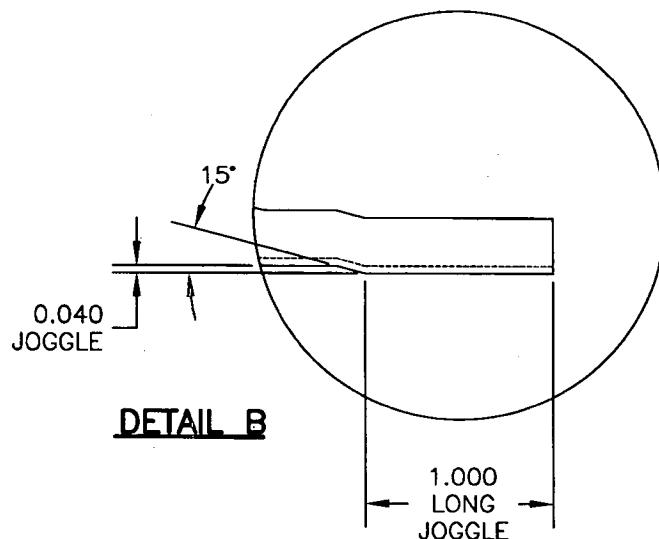
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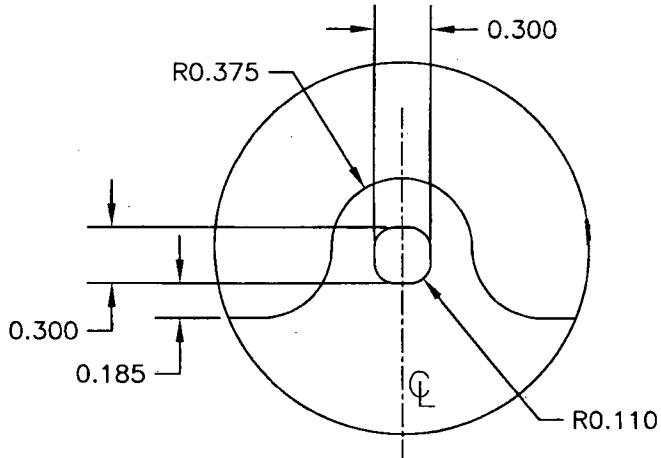
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PP	PP	D3535
DATE		TITLE
06.10.25		WEARSHOE

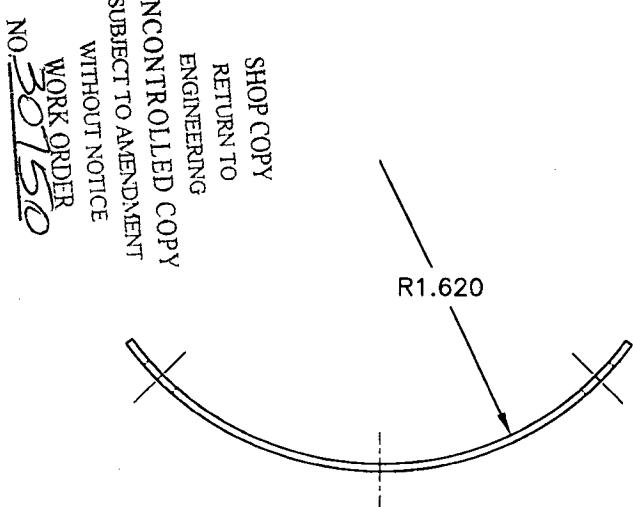
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DETAIL B



DETAIL A



SECTION C-C

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NO. 30750

DART AEROSPACE LTD	Work Order:	30750
Description:	Part Number:	D3535-15
Inspection Dwg: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	SAD
Date:	07/02/25

Audited by:	SG
Date:	07.02.25

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	